

Work Order ID 121432

121432

July-31-14 10:27:39 AM

Page 1

Item ID: D4868-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Leg Assembly ***8*** Cust-Item ID:
 Start Date: 6/26/14 Start Qty: ~~8.00~~ ***8*** Customer:
 Required Date: 6/26/14 Req'd Qty: 8.00 ***8***
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4868	C								

110 0.00
110
 Small Fab Memo 0.00 2 FF DEC 15 2014
 Small Fab

ALIGN PILOT HOLES IN D4868-1 WITH PILOT HOLES IN D4871-1 AND
 D4871-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9965 AS PER DWG.

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00 (2) DAS
 Quality Control 38
 9-89

DEC 15 2014

July-31-14 10:27:39 AM

Item ID: D4868-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 206L Leg Assembly

Stop *NS2*

Start Date: 6/26/14 **Start Qty:** 8.00

g

Cust Item ID:

Required Date: 6/26/14 **Req'd Qty:** 8.00

g

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

Memo

0.00

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL
WET AS PER DWG USE DT9965
A/R HYSOL BATCH: M131002

2 FF DEC 16 2014

140

QC5- Inspect part completeness to step on W/O	0.00
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140

QC

Memo

0.00

Quality Control

② _____

DAS
38
9-8

DEC 16 2014

150

Outsource process - Laser Marking	0.00
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150

Outsource9

Memo

0.00

Outsource process - Laser Marking

ISSUE P/O : 26854
OUTSOURCE VENDOR: P&L PRINTING
ENGRAVE P# AS PER DWG

C OF C IS REQUIRED

CZ 14/12/18 2

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121432

Page 3

Item ID: D4868-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 6/26/14 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/26/14 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.00

Packaging

2x SP15-01-20

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

(2)

DAS
38
9-89

JAN 20 2015

180

Identify as per dwg & Stock Location: 81/33 0.00

180

Packaging

Memo

0.00

Packaging

2x

DAS
26
9-89

JAN 21 2015

Work Order ID 121432***121432***

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Item ID: D4868-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 206L Leg Assembly

Stop

NS2

Start Date: 6/26/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 15-01-23

15.1-22

Picklist Print

July-31-14 10:27:38 AM

Work Order ID: 121432

Parent Item: D4868-041

Parent Item Name: 206L Leg Assembly

121432

D4868-041

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Stat
D4868-1 *D4868-1* Strut		Manufactured	No		121389		Each	0.0000	**	2	FF	DEC 15 2014	
D4871-1 *D4871-1* End Fitting		Manufactured	No				Each	3.0000	**	8	FF	DEC 15 2014	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124	122289			3		1			
					112018			3		1			
D4871-3 *D4871-3* End Fitting, Eye		Manufactured	No				Each	3.0000	**	8	FF	DEC 15 2014	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124	123526			3		1			
					117329			3		1			
HL20PB5-12 *HI 20PB5-12* Rivet		Purchased	No				Each	176.0000	**	32	FF	DEC 15 2014	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST265	1129912			176		8			
					1129912			34					
					M128110			142					
					M128973								

Pa

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____

Picklist Print

Page 2

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Work Order ID: 121432

121432

Parent Item: D4868-041

D4868-041

Parent Item Name: 206L Leg Assembly

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 8.00

Required Qty: 8.00

HL86-5

Purchased

No

Each

1,221.000

32

HI 86-5

**

FF

DEC 15 2014

Collar

Location

Loc Qty

Loc Code

ST263

1221

M128110

12

M128228

29

M129022

200

M129864

980

July-31-14 10:27:38 AM

Shop Packet Print

Page 2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26854**

Purchase Order Date 12/18/2014

PO Print Date 12/18/2014

Page Number 2 of 3

Order From :

VC-PL001

Ship To : DART AEROSPACE LTD

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Total:

\$8.0

4 121432

D4868-041 LEG
ASSEMBLY

12/23/2014

2.00

\$4.00

\$8.0

Yes

12/23/2014

LASER MARKED

Line Total:

\$8.0

5 116518

D4834-042 LEG
ASSEMBLY

12/23/2014

2.00

\$4.00

\$8.0

Yes

12/23/2014

LASER MARKED

Line Total:

\$8.0

6 71401-45

PROCUREMENT
QUALITY CLAUSES

12/23/2014

1.00

\$0.00

\$0.0

No

12/23/2014

Quality Procurement Clauses

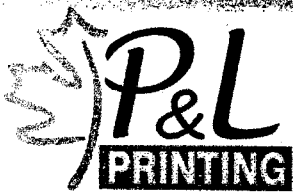
A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A042 DART NOTIFICATION BY SUPPLIER

Note:

12/18/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2580
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE January 14, 2015

P.O NUMBER PO26854

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4804-041 BIPOP ASSEMBLY

1

ALL ITEMS HAVE BEEN LASER MARKED

D4868-042 LEG ASSEMBLY

2

D4803-041 LEG ASSEMBLY

2

D4868-041 LEG ASSEMBLY

2

D4834-042 LEG ASSEMBLY

2

SP15-01-20



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7524

Date: January 14, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
26854		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4804-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4868-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4803-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4868-041 ✓	✓ 2.00	4.00	✓	8.00
Laser Metal Marking, D4834-042	2.00	4.00	✓	8.00
Sub-Total				\$36.00
				13.00% on 36.00
				Total \$40.68

SP15-01-20

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You